



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

ASAP

D3204-9
Job Sheet 180931



Part No: D3204-9

Job Qty: 10 ea

Part Name: Pedal



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/18/18

Job Tracking No:

Due Date: ~~7/20/18~~ 8/15

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A1 IPP: C 05.08.11 Added Step 25 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		7/20/18	0.00	0.00	Start Up Machining-2		DAS
100	Bandsaw	10 pcs		7/20/18	0.00	0.01	Bandsaw1		54
110	CNC Vertical Machining	10 pcs		7/20/18	0.25	6.41	HAAS1-3		9-89
130	QC	10 pcs		7/20/18	0.00	0.00	QC8 Machining-2		7/18/10/26
140	Packaging	10 pcs		7/20/18	0.00	0.00	Packaging3-1		EL
150	QC21-SA	10 Ea		7/20/18	0.00	0.00	QC21		DAS

Part Op 100 - Cut blank: 2.000" x 0.375" x 3.100" long Bar

Descriptions: 110 - 1- Machine as per Folio FA357 and Dwg D3204 Identify as D3204-9

140 - *****STOCK IN LARGE FAB*****

21
9-89 AUG 0 2 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X2.000	6061-T6 Bar .375 X 2.00	2.6880 ft (.2688 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X2.000	3	43	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Pedal	0.500inches $\pm$ 0.030	0.530 0.470		
2	Pedal	0.250inches $\pm$ 0.010	0.260 0.240		
3	Pedal	0.080inches $\pm$ 0.010	0.090 0.070		
4	Pedal	0.110inches $\pm$ 0.010	0.120 0.100		
5	Pedal	45Degrees $\pm$ 0	45 45		
6	Pedal	0.620inches $\pm$ 0.010	0.630 0.610		
7	Pedal	3.000inches $\pm$ 0.010	3.010		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																															
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DART Aerospace Ltd. 1270 Aberdeen Street Howicksbury, ON K6A 1K7 CANADA TEL: 513 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/26/16 Container No: S096583 Part: D3204-9 Job No: 180931 Serial No/Batch: S096583 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's				Completed By _____																																																																																																																			
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Container No: S096583



Part: D3204-9

Job No: 180931

Serial No/Batch: S096583

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: Various STC's

Date: 07/26/16

			2.990
8	Pedal	2.000inches ± 0.030	2.030 1.970
9	Pedal	0.310inches $+ 0.010$ $- 0.000$	0.320 0.310
10	Pedal	0.780inches ± 0.010	0.790 0.770
11	Pedal	1.750inches ± 0.010	1.760 1.740
12	Pedal	0.134inches $+ 0.005$ $- 0.000$	0.139 0.134

Plex 7/18/18 9:20 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

